

Work Order ID 86675

86675

Page 1

July-06-12 11:21:32 AM

Item ID: D3239-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cover
 Start Date: 7/06/12 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: *ll* Date: 12-07-12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3239 | Rev A | | | | | | | | |

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet I-Cut as per Dwg D3239 Dwg Rev: A Prog Rev: A 2-
 6061 .050 Debur if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

SMB
 12-7-23

DAS
 16
 12/13/23

18 0 JM 12-7-22

18 0 JM 12-7-22

18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 86675

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Page 2

July-06-12 11:21:32 AM

Item ID: D3239-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cover

Start Date: 7/06/12

Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

Debur if necessary.

0.00

0.00

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

18 / 12-7-23

150

150

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

18 X / M-L 12/07/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

86675

July-06-12 11:21:32 AM

N900040100

Stop *NS2*

Reference:

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

12/7/24 J
mc
12-07-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

July-06-12 11:21:32 AM

Page 1

Work Order ID: 86675

Parent Item: D3239-1

Start Date: 7/06/12

Required Date: 8/10/12

Parent Item Name: Cover

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev: A New Issue 05-11-06 JLM
IPP: b 06.11.15 waterjet EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|------------------------------|---------------|----------------|--------|
| M6061T6S.050 6061-T6 .050 Sheet | | Purchased | No | | | 100 | sf | 146.4640 | 0.18 | 3.0315792 3.25 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | 021 | | 99.675 | | | | | | | |
| | | | | 1211920 | | 99.675 | | | | | | | |
| | | | | MAT021 | | 46.789 | | | | | | | |
| | | | | 114799 | | 31.789 | | | | 114799 | | | |
| | | | | 114993 | | 15 | | | | | | | |

Jan 12-7-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

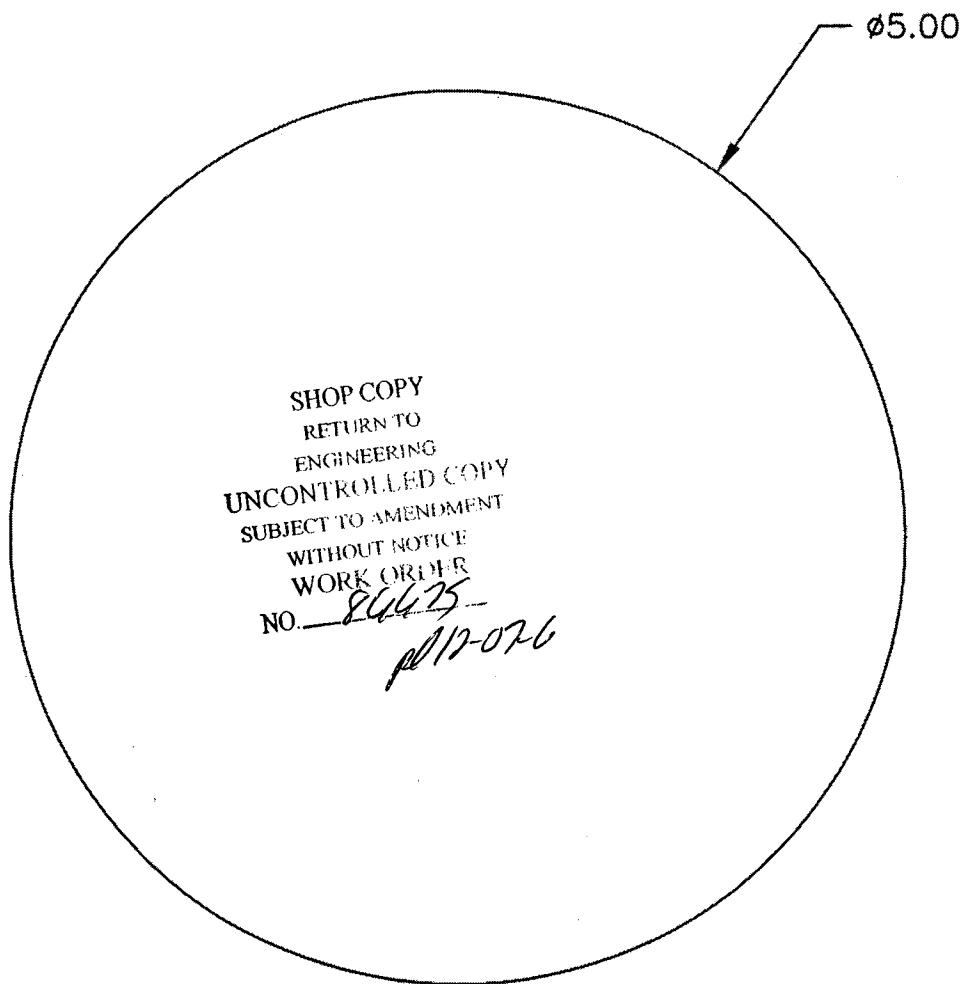
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3239 | REV. A SHEET 1 OF 1 |
| DATE 03.12.19 | | TITLE COVER | SCALE 1:1 |
| A | 03.12.19 | NEW ISSUE | |

RELEASED
04.02.03



D3239-1 COVER

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK (REF. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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